

# Work Order ID 78080

\*78080\*

Page 1

December-28-11 3:25:37 PM

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH

Start Date: 28/12/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/12/28 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

8/12/15

for MCT 12-2-14  
①

78080.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78080****\*78080\***

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December-28-11 3:25:37 PM

Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

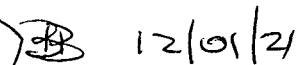
6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 78080

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Item ID: D350-636-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: *M119712*

12-Grind welds flush as per Dwg D2750

*BE 12-01-23*  
*DICF 12-1-23*

120

QC10- Inspect visual per QSI004- ground welds 0.00

**\*120\***

QC  
Quality Control

Memo 0.00

*5/12/13*

130

QC5- Inspect part completeness to step on W/O 0.00

**\*130\***

QC  
Quality Control

Memo 0.00

*8/12/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***Start Date: 28/12/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

12-1-24

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1 0 BE 12-01-24

W/O: 78080		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
2-1-24	150	Should read QC 7	<i>[Signature]</i>	2-1-24			<i>[Signature]</i>

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <i>PC</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 78080

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M119999

exp. date: 2012-08-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M119712

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

B 12/01/26

CF

12-1-27

B 12/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 78080

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

> B 12/01/31

8126261

8126261

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78080****\*78080\***

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Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*1X M-12/02/01*

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*200\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

210 QC3- Inspect Part Finish

0.00

**\*210\***

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

*1X M-12/02/02**1 BL 12-2-8-*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 78080****\*78080\***

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00

**\*220\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

1 BL 12-28-

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A.

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 120125.EXP DATE: 12-8.4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube  
A/R 55-o-ring lube batch: 1103485-Coat all exposed fasteners with "LPS Procyon" batch: 114506.

1 BL 12-2-8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 78080**

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**\*78080\***

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Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*  
  
Handwritten notes: 8/12/02/09, 8/12/02-15, 8/12/07/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D350-636-011

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 28/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
	FG 072 NEVI								
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/2/16 (1)

12/2/17

12-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 78080

**\*78080\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

**Comments:**  
 IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verf:EC IPP Rev:P 10.06.22 revise  
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	110.0000	8	8			
<b>*D3492-1*</b>									<b>**</b>			<i>BR 12-2-8.</i>	
Plug													

Location	Loc Qty	Loc Code
FP002	110	
69531	8	
74444	2	
76235✓	100	

D3492-3		Manufactured	No			230	Each	29.0000	8	8			
<b>*D3492-3*</b>									<b>**</b>			<i>BR 12-2-8.</i>	
Plug													

Location	Loc Qty	Loc Code
FP002 <i>77039</i>	29	
74447	17	
74871	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

87.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

BL 12-2-8

Location

Loc Qty

Loc Code

FP001

20/21

87

110915

14

117460

8

118077

1

118612

3

119438

47

119623

14

8.

NAS1149D0863J

Purchased

No

250

Each

161.0000

2

2

\*NAS1149D0863.J\*

WASHER

\*\*

SP 12-02-15

Location

Loc Qty

Loc Code

ST298

161

118078

61

119307

100

~~8x~~

2x

D2744

Manufactured

No

110

Each

34.0000

1

1

\*D2744\*

Cap

\*\*

BL 12-01-23

Location

Loc Qty

Loc Code

LG002

34

62715

1

70881

12

71861

21

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

26.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

① BE 12/01/21

Location

Loc Qty

Loc Code

LG

26

66875

7

73253

1

75021

1

75022

1

75023

1

77623

15

D2743

Manufactured No

160 Each

169.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

BE 12-01-30

Location

Loc Qty

Loc Code

LG001

169

67766

4

68251

3

73403

64

74445

92

76141

6

D2739

Manufactured No

160 Each

4.0000

1

1

\*D2739\*

350 I Beam

\*\*

Location

Loc Qty

Loc Code

LG

4

72155

1

76987

3

B78898

①

CF 12-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78080

**\*78080\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 22.0000 4 4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE12-01-30

B 77567 \*4

Location

Loc Qty

Loc Code

LG001

22

74877

22

D3490-1 Manufactured No

160 Each 70.0000 4 4

**\*D3490-1\*** ✓

Cross Bolt Spacer

\*\*

BE12-01-30

Location

Loc Qty

Loc Code

LG001

70

62450

2

67773

4

74875

24

77042

40

ALS4-1032-225 Purchased No

220 Each 1,132.000 38 38

**\*ALS4-1032-225\***

Insert

\*\*

BE12-28.

Location

Loc Qty

Loc Code

ST281

1132

108696

199

110768

62

118386

803

118966

68

D3793-3 Manufactured No

230 Each 14.0000 1 1

**\*D3793-3\***

Wearshoe

\*\*

BE12-28.

Location

Loc Qty

Loc Code

FP001

14

74528

2

75043

12

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

81.0000

1

1

\*AN8C35A\*

BOLT

\*\*

BL 12-2-8.

## Location

## Loc Qty

## Loc Code

FP002

80

115960

1

117834

23

118286 ✓

56

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

10.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

BL 12-2-8.

## Location

## Loc Qty

## Loc Code

FP001

10

77029

75038

10

D3488-041

Manufactured

No

230

Each

14.0000

1

1

\*D3488-041\*

Blade Fitting Assembly, LH

\*\*

BL 12-2-8.

## Location

## Loc Qty

## Loc Code

FP002

14

77021.

61689

1

69903

4

75056

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

13.0000

1

1

\*D3794-3\*

Gasket

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FP002

78895.

13

74530

2

74596

11

1

AN6C44A

Purchased

No

230

Each

35.0000

4

4

\*AN6C44A\*

BOLT

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FG

120465.

2

103964

2

ST343

33

118985

3

119125

30

4

MS21083C8

Purchased

No

230

Each

42.0000

1

1

\*MS21083C8\*

NUT

\*\*

BL 12-2-8

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

41

115884

0

118077

1

118614

7

119309

2

119436

25

119638

6

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each

19.0000 1 1

\*D3536-25\*

Gasket

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FP002

19

75039 ✓

19

1

D3631-1

Manufactured No

230 Each

351.0000 8 8

\*D3631-1\*

Washer

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

ST072

351

68062

2

75548 ✓

349

8

D3791-1

Manufactured No

230 Each

21.0000 1 1

\*D3791-1\*

Wearplate

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FP002

21

62239

2

74598

3

75041 ✓

16

1

AN960C10L

✱ NAS1149C0332 ✓  
P R

Purchased

No

230 Each

0.0000 38 38

\*AN960C10I \*

washer

\*\*

BL 12-2-8.

12068

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No

230 Each

89.0000 8 8

\*D2745\*

Bushing

\*\*

BL 12-28

Location

Loc Qty

Loc Code

FP001

78577.

89

69529

1

76142

88

8.

AN3C5A

Purchased No

230 Each

898.0000 34 34

\*AN3C5A\*

Bolt

\*\*

BL 12-28

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

891

116419

28

117343

17

117764

49

117872

2

119127

500

119749

295

34.

D3537-1

Manufactured No

230 Each

26.0000 3 3

\*D3537-1\*

Wearpad

\*\*

BL 12-28

Location

Loc Qty

Loc Code

FP002

77560.

26

69817

5

74867

21

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

320.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

ST297

320

114915 ✓

320

1

AN3C6A

Purchased

No

230

Each

226.0000

4

4

\*AN3C6A\*

BOLT

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

225

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449 ✓

100

119749

57

4.

NAS1611-013

Purchased

No

230

Each

96.0000

8

8

\*NAS1611-013\*

O-RING

\*\*

BL 12-2-8.

Location

Loc Qty

Loc Code

FP001

96

116582

5

117291

2

117887

53

119623

36

4.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78080

**\*78080\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

17.0000 1 1

**\*D3535-25\***

Wearshoe

\*\*

*BL 12-2-8*

Location

Loc Qty

Loc Code

FP001

77617.

17

62233

1

74592

4

75040

12

D3794-1

Manufactured No

230 Each

31.0000 1 1

**\*D3794-1\***

Gasket

\*\*

*BL 12-2-8*

Location

Loc Qty

Loc Code

FP002

31

74594

3

75042 ✓

28

MS21043-6

Purchased No

230 Each

377.0000 4 4

**\*MS21043-6\***

NUT

\*\*

*BL 12-2-8*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

357

112314 ✓

147

117887

10

118384

200

*4.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

17.0000

2

2

\*D3493-1\*

Washer

\*\*

B77573 SP  
22.

Location

Loc Qty

Loc Code

ST062

17

70697

2

76237

15

MS21083C8

Purchased No

250 Each

42.0000

2

2

\*MS21083C8\*

NUT

\*\*

m/20/42 . 21  
SP 12-02-15

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

41

115884

0

118077

1

118614

7

119309

2

119436

25

119638

6

AN8C21A

Purchased No

250 Each

31.0000

2

2

\*AN8C21A\*

BOLT

\*\*

m/20094  
SP 12-02-15

Location

Loc Qty

Loc Code

ST343

31

118758

5

119530

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78080

\*78080\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

183.0000

4

4

\*NAS1515H3I \*

WASHER

\*\*

BK 12-2-8

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

143

118686

3

119438

40

120072 ✓

100

4

D2741

Manufactured

No

250

Each

18.0000

1

1

\*D2741\*

Blade, 350 Skidtube

\*\*

B76984 18

SP 12-02-15

Location

Loc Qty

Loc Code

ST

-10

ST466

28

71856

18

Manufactured

No

250

Each

22.0000

2

2

D3532-1

\*D3532-1\*

Spacer

\*\*

B78839

SP 12-02-15

Location

Loc Qty

Loc Code

ST065

22

74880

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL) WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
SHEET 1 OF 11

TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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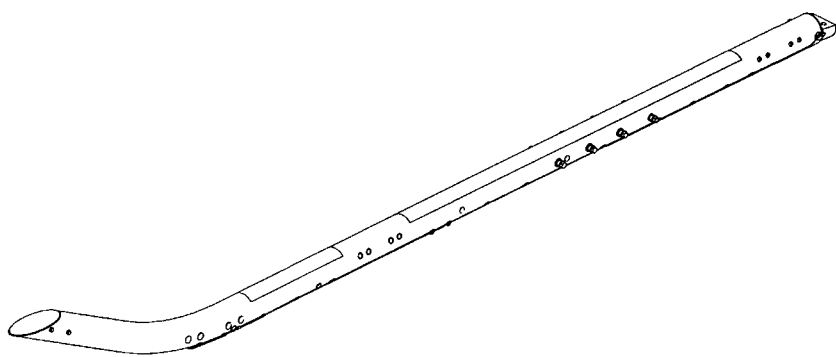
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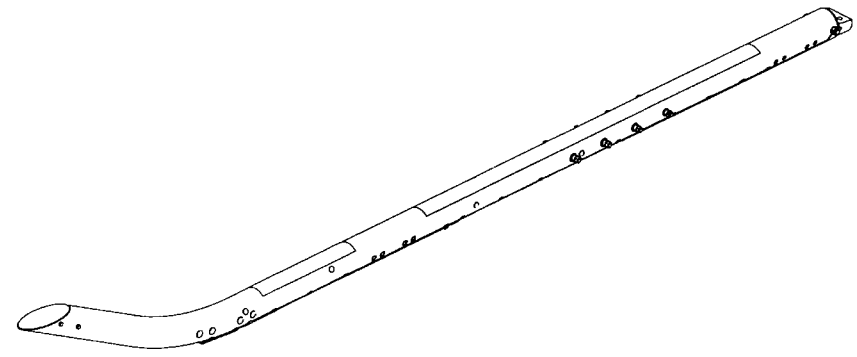
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

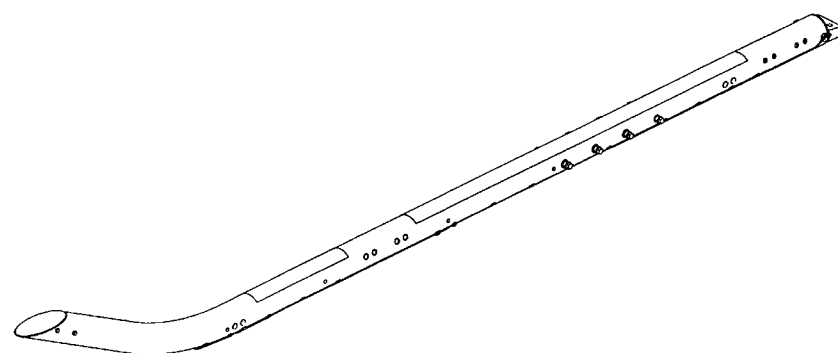
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

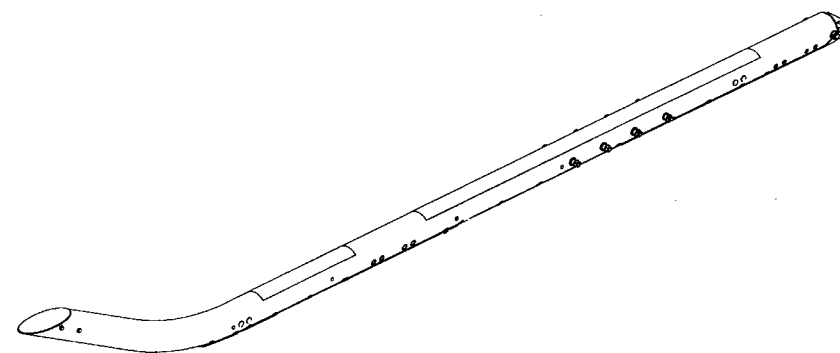
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

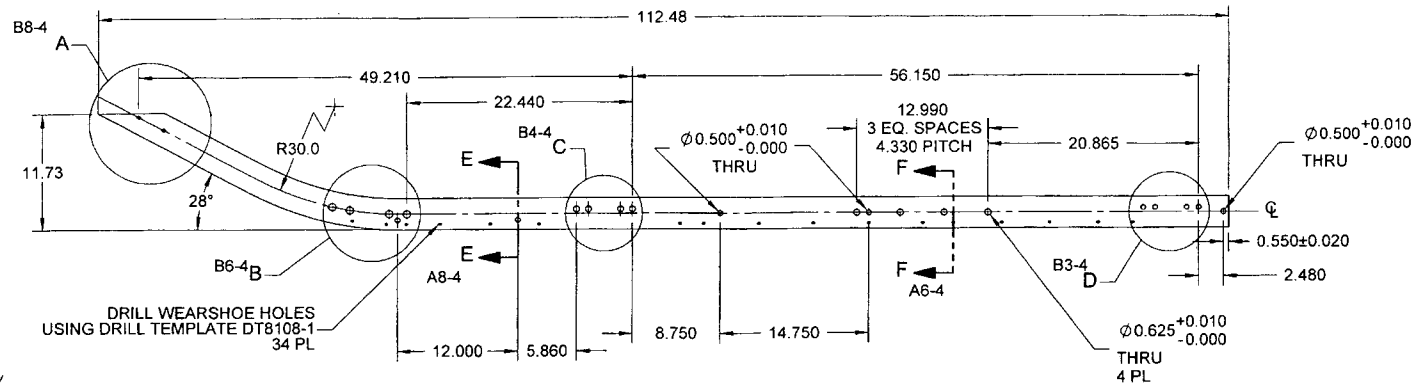
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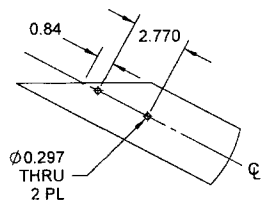
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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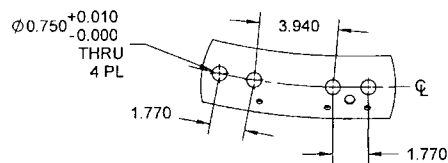
7 Feb 80



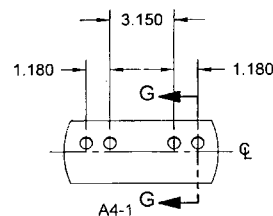
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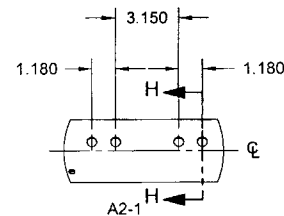
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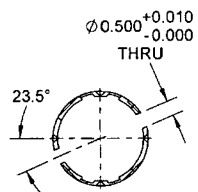
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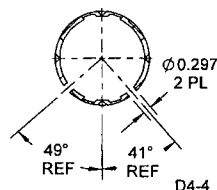
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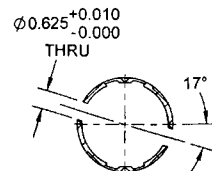
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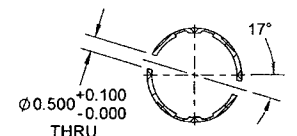
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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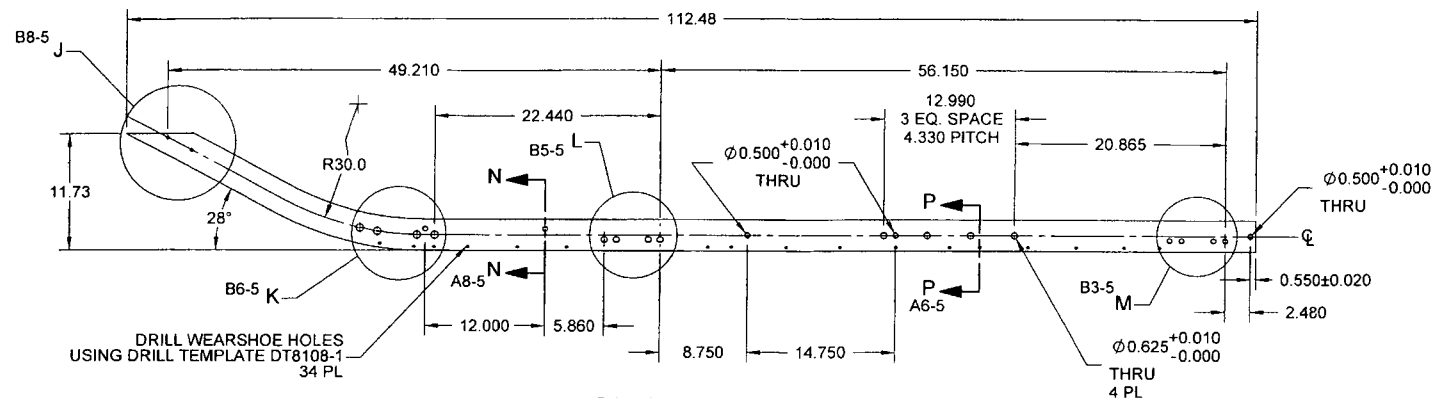
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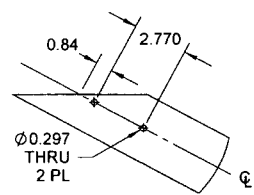
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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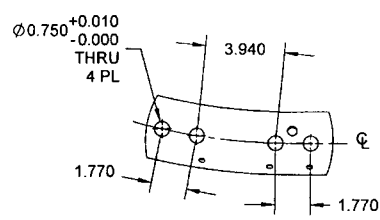
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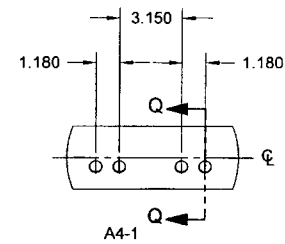
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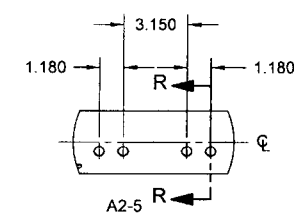
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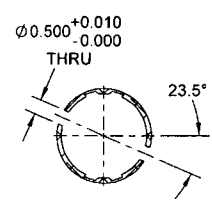
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SCALE 2X



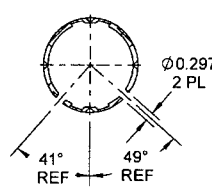
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SCALE 2X



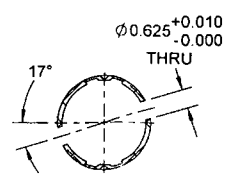
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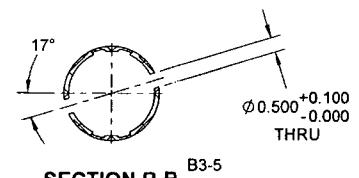
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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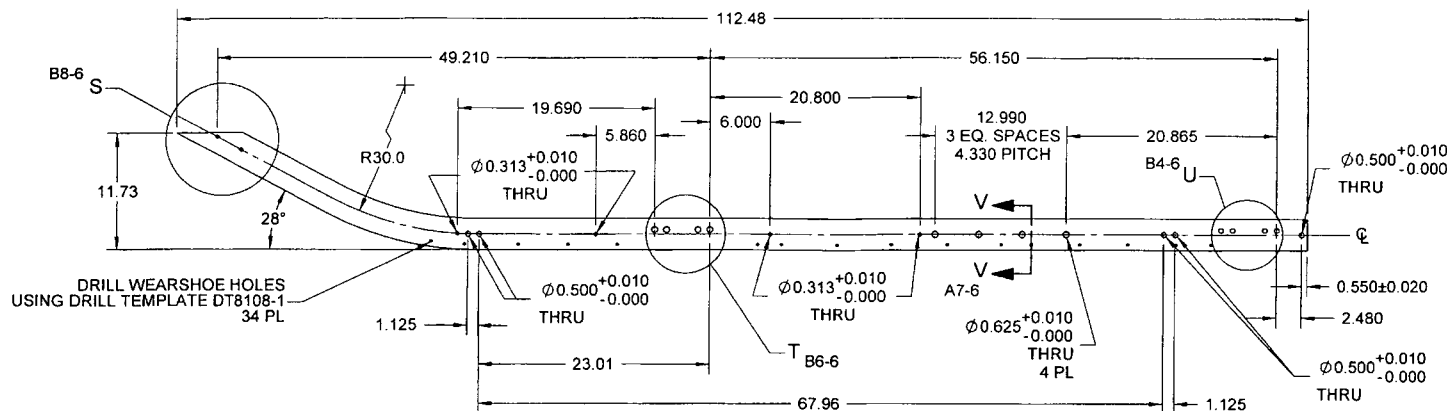
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

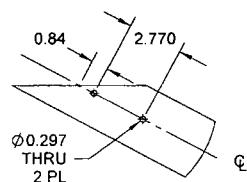
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

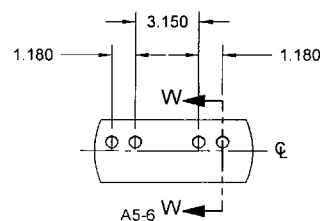
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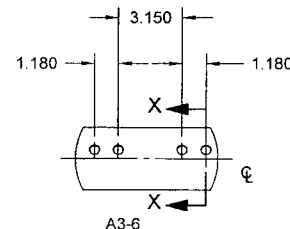
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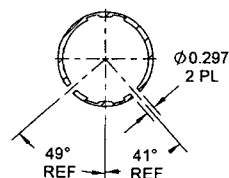
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D8-6  
SCALE 2X



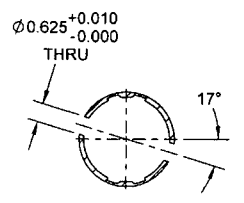
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C5-6  
SCALE 2X



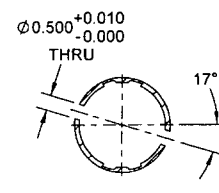
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

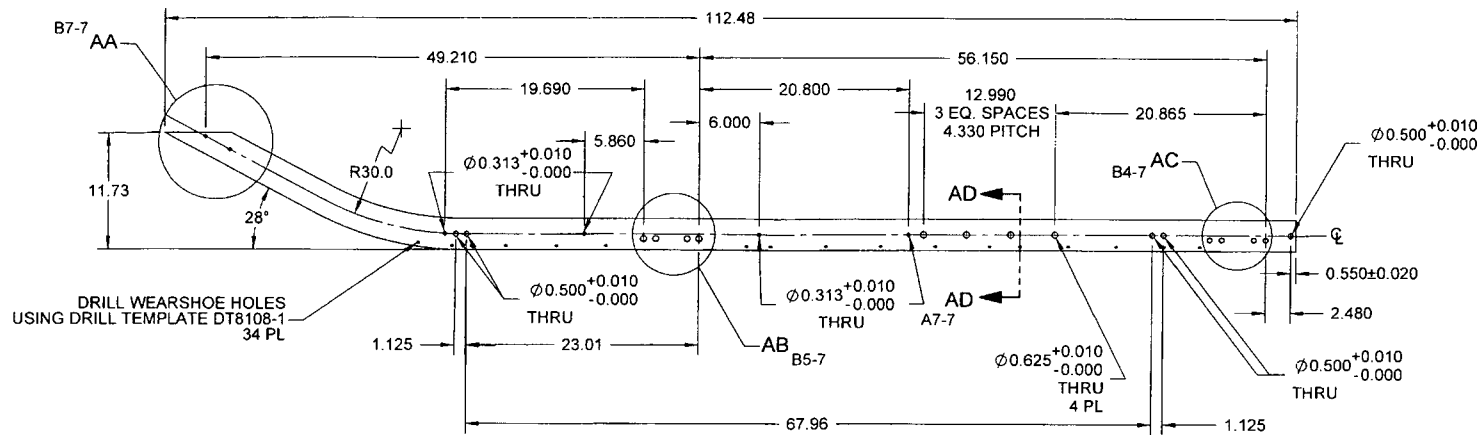
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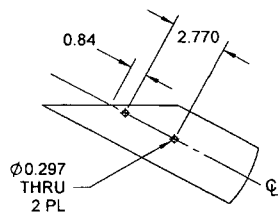
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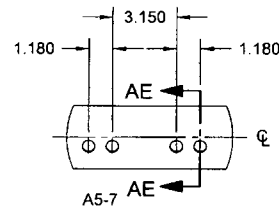
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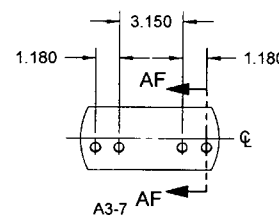
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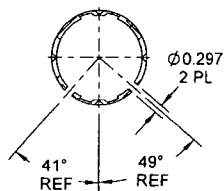
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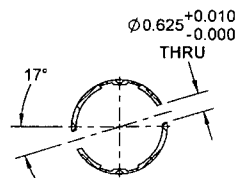
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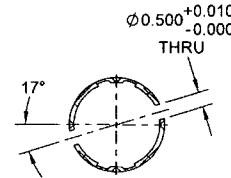
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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**Dart Aerospace Ltd**

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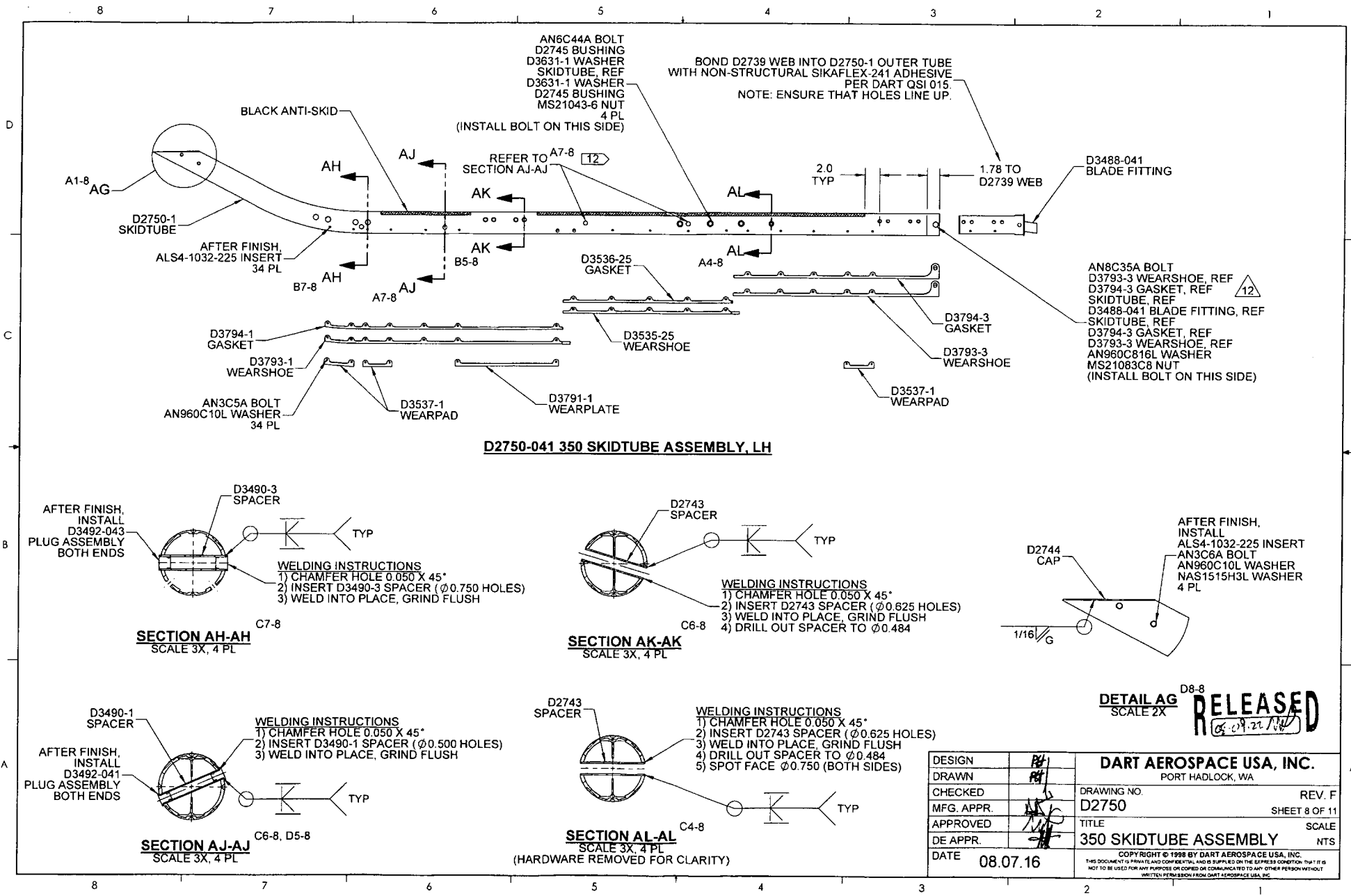
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DETAIL AG D8-8  
SCALE 2X  
**RELEASED**  
6.09.2014

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APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

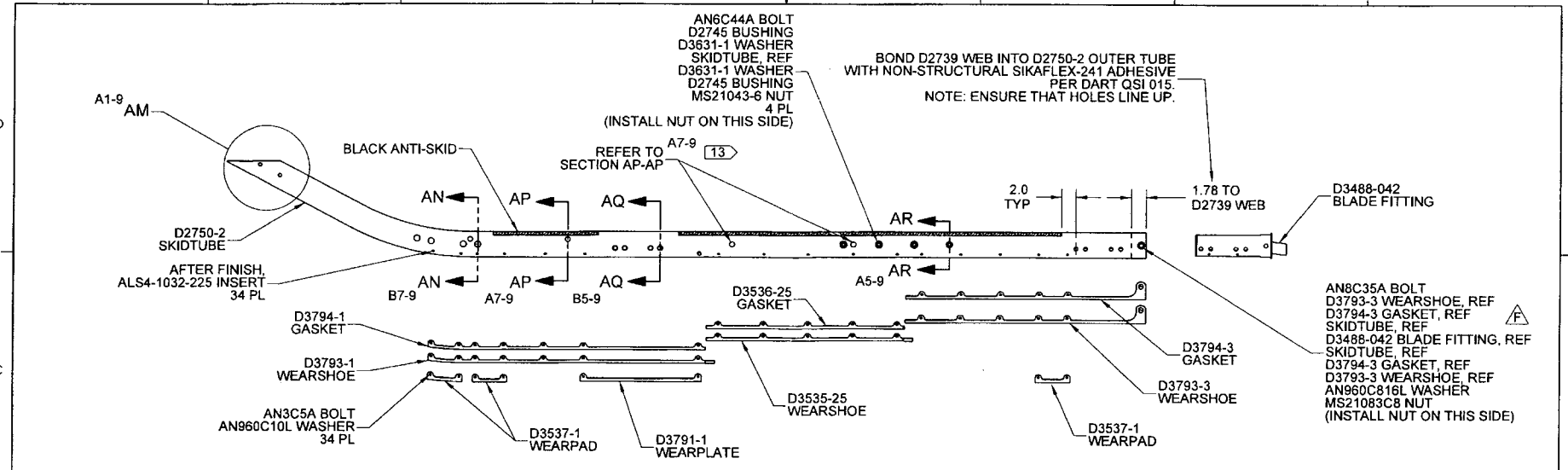
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

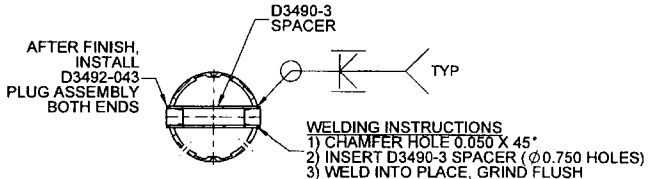
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

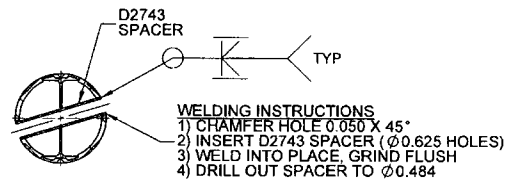
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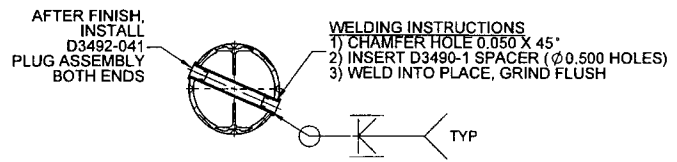
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



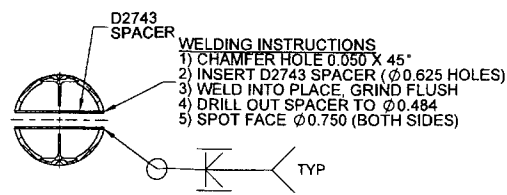
**SECTION AN-AN**  
SCALE 3X, 4 PL



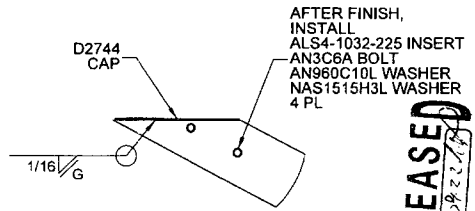
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AM**  
SCALE 2X

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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RELEASED  
22260380

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

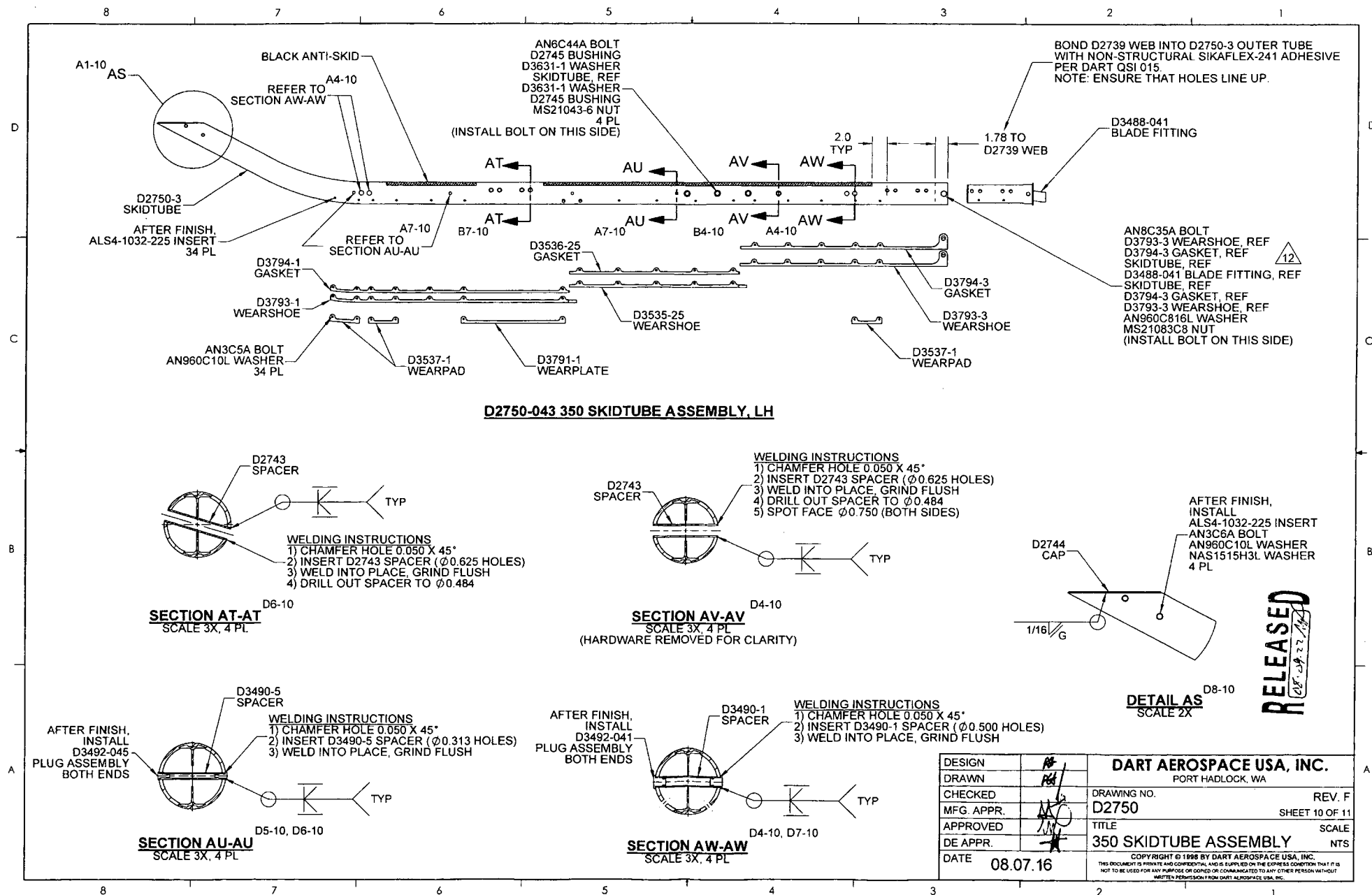
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78080



DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 10 OF 11
APPROVED	REV. F	TITLE	SCALE
DE APPR.	REV. F	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

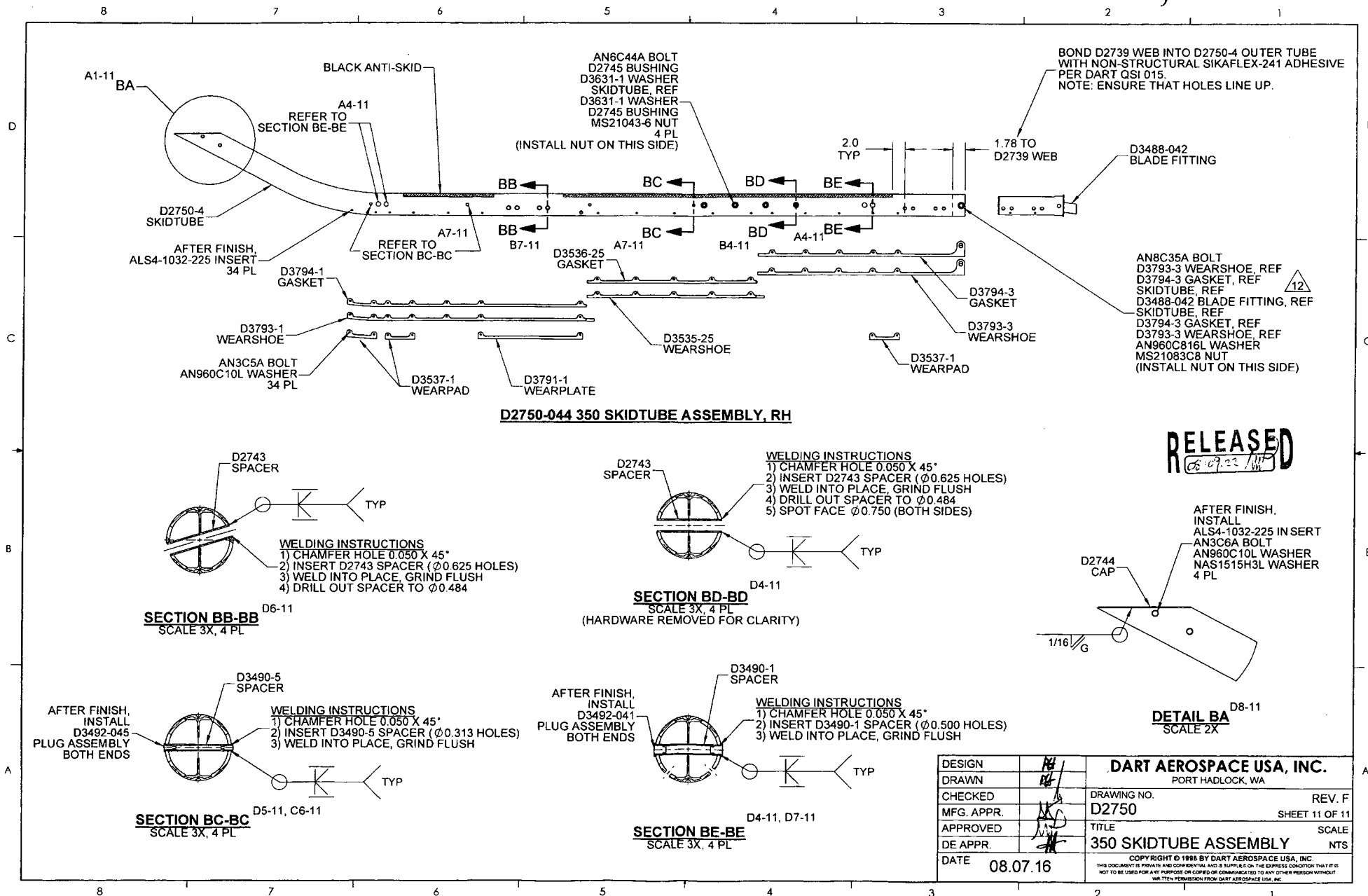
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



70080



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 282

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 78413  
Part number: A350-636-011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Newell Date of Test Coupon 12.02.01

Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld